



Date: Wednesday, 12/11/2008 2:18:50 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	"T" HANDLE ASSEMBLY
Job Number :	43400		
Estimate Number :	11179		
P.O. Number :		Part Number :	D2282041
This Issue :	12/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2282 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	43185	Drawing Revision :	E
Written By :		Material :	
Checked & Approved By :		Due Date :	12/11/2008
Comment :	Est Rev A Removed from 9 Digit 05-12-02 JLM	Qty:	4
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22823	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

✓	Qty Part Number	Description	Batch
	1 D2282-3	Handle tube	341889

FL 8-11-12

2.0	D22825	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

✓	Qty Part Number	Description	Batch
	1 D2282-5	Handle tube	341890

FL 8-11-12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly
 Grind chamfers and ensure full penetration.as per dwg D2282
 *****brush weld right after welding, to take color off *****

A/R ER316L SS Filling Rod M106/115
 Dwg Rev: E

FL 8-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 43400

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC9

VISUAL WELDING INSPECTION



(X4)

Comment: VISUAL WELDING INSPECTION

Pl 08-11-12

08/11/12

(4)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

08/11/12

(4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 08/11/12

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



mf 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

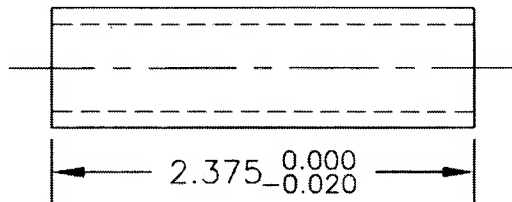
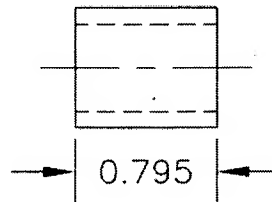
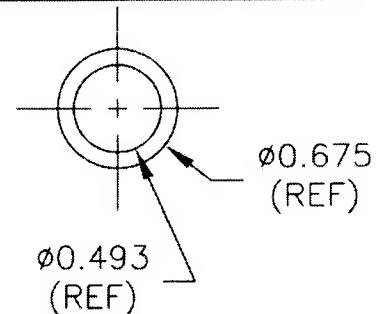
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

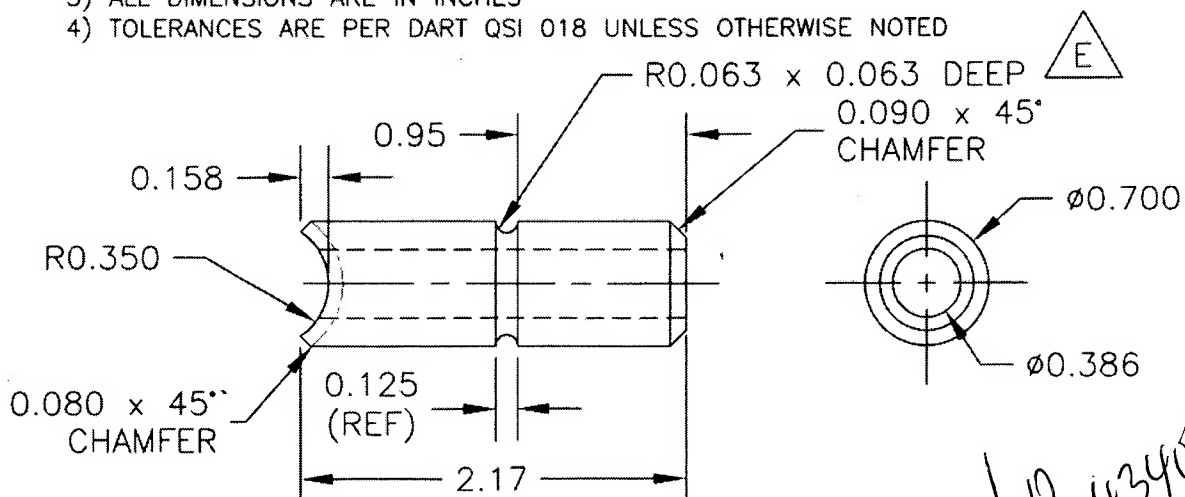
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

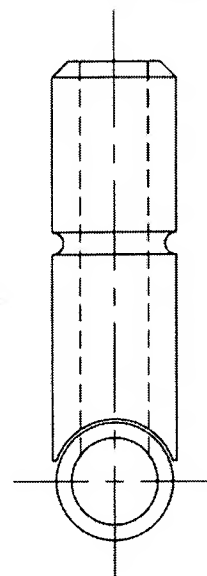
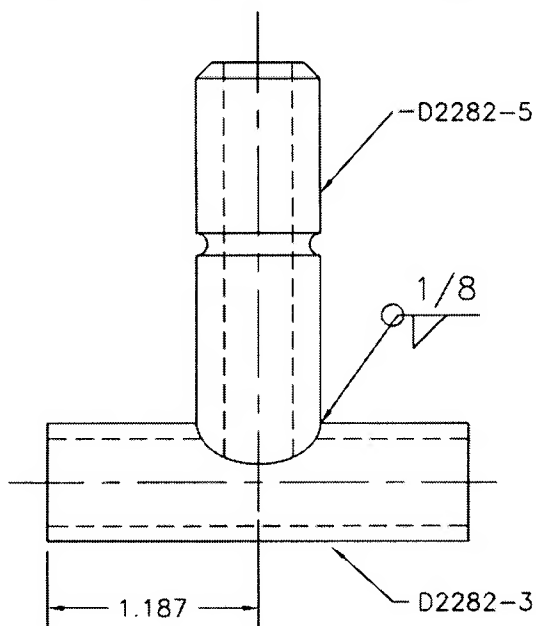
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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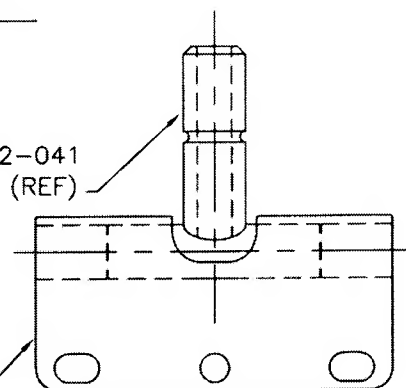
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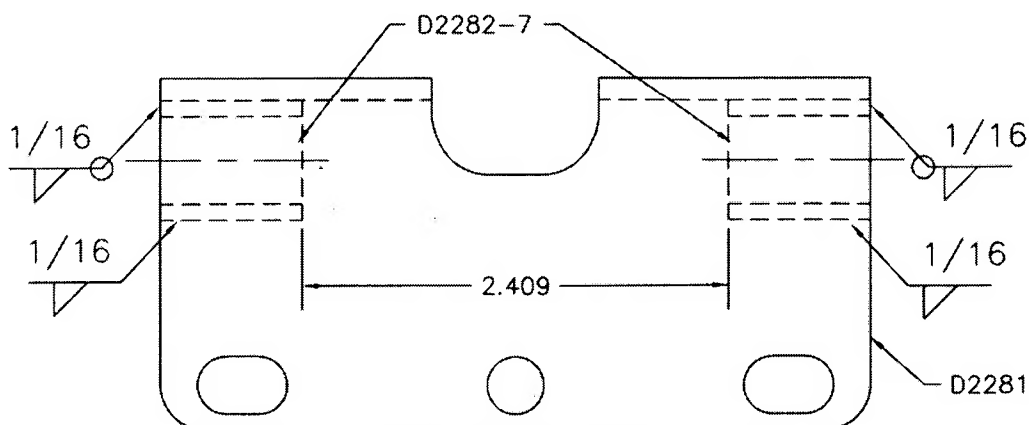
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

Wo 43400

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